

Date: Monday, 26/05/2008 9:53:49 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 39475			Part Number	: D2573	
Estimate Number	: 10533			Drawing Number	: D2573 REV E	
P.O. Number	:			Project Number	: N/A	
This Issue	: 26/05/2008		S.O. No.	: :		
Prsht Rev.	: NC			Drawing Revision	: E	
First Issue	: / /		Type	: MACHINED PARTS		
Previous Run	: 38922			Material	:	
Written By	:			Due Date	: 10/06/2008	
Checked & Approved By	: <u>JL</u> 08.5.23			Qty:	10 Um: Each	
Comment	: Est: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>39475</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>39475</u> Double check by: <u>JL</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8/08/07/03

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fd 08/07/04

7.0 POWDER COATING POWDER COATING



m107925

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(S)

START TIME: 7:25

OVEN TEMPERATURE: 320

FINISH TIME: 7:55

Fd 08/07/07

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(S)

Comment: INSPECT POWDER COAT

bk 08-07-07

9.0 PACKAGING 1 PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 433

8/1/7

54

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/07/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6/08/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39475
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

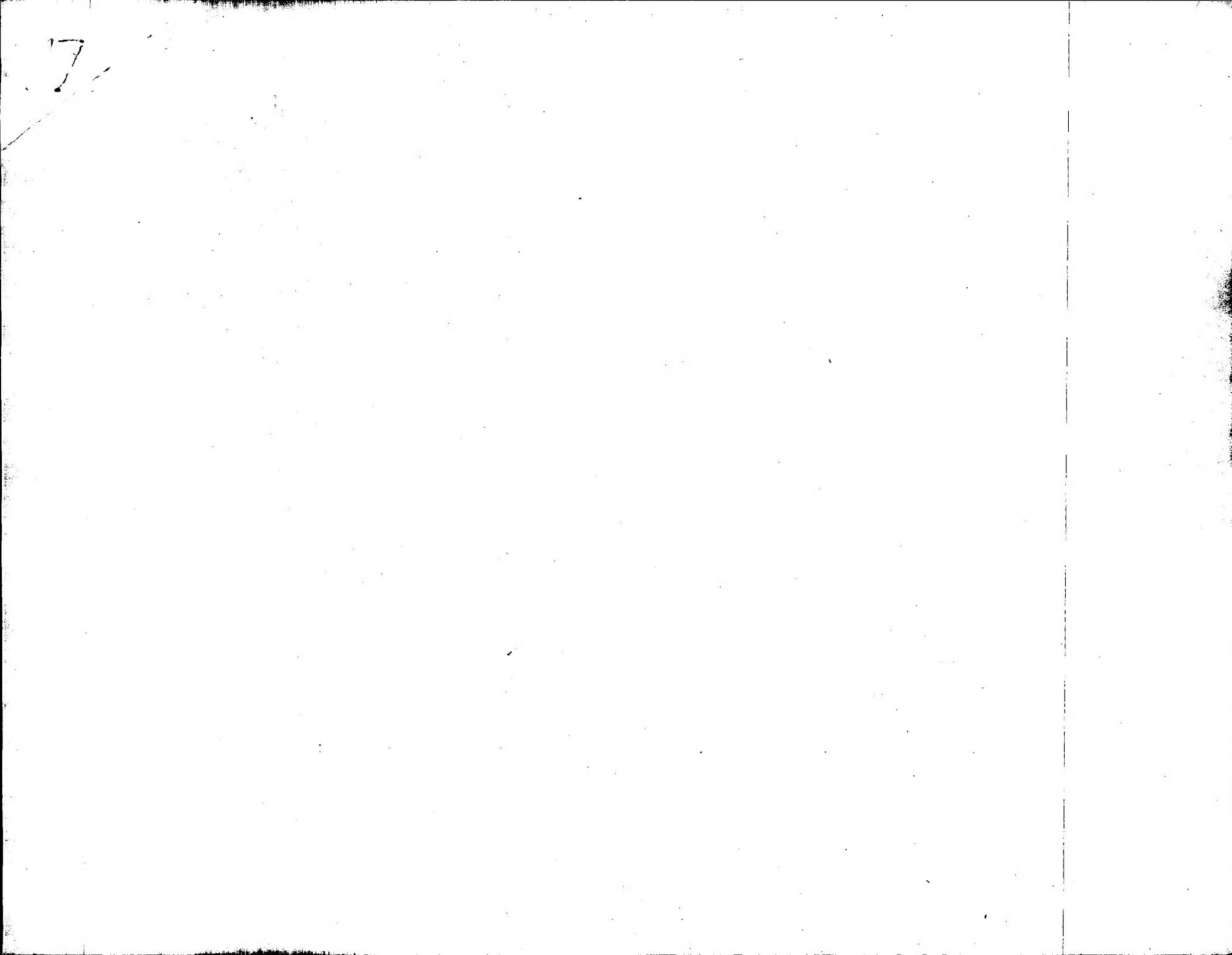
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.443	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	8.000	8.001	8.000		
F	0.490	0.510		.500	.502	.500	.499		
G	0.257	0.262		.258	.258	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.501	.501	.502	.503		
J	1.174	1.184		1.178	1.180	1.180	1.186		
K	0.558	0.578		.568	.568	.567	.568		
L	1.174	1.184		1.178	1.180	1.180	1.180		
M	1.365	1.375		1.368	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.120	4.124	4.124	4.122		
P	0.115	0.135		.126	.126	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.250	.251	.251		
S	0.115	0.135		.118	.124	.123	.124		
T	0.178	0.198		.138	.188	.188	.188		
U	3.210	3.250		3.227	3.229	3.229	3.232		
V	0.230	0.250		.239	.240	.240	.240		
W	0.115	0.135		.120	.128	.129	.127		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.371	.366	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.632	.625	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.248	.247	.246		
AE	1.500	1.520		1.513	1.512	1.512	1.511		
AF	0.115	0.135		.132	.129	.129	.127		
AG	0.240	0.280		.260	.260	.266	.260		
AH	0.240	0.260		.247	.250	.249	.249		
AI	2.000	2.020		2.002	2.001	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	Amel / JL	Audited by:	88
Date:	08/07/02 / 08/07/03	Date:	08/07/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK SJM



DART AEROSPACE LTD	Work Order:	39475
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.000	8.000		
F	0.490	0.510		.498	.501	.499	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.501	.501	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.125	4.124	4.124		
P	0.115	0.135		.123	.124	.123	.122		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.250	.250		
S	0.115	0.135		.123	.124	.124	.123		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.230	3.230		
V	0.230	0.250		.240	.240	.241	.242		
W	0.115	0.135		.125	.126	.125	.124		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.365	.365	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.250	.250	.251		
AE	1.500	1.520		1.514	1.513	1.514	1.513		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.248	.249	.251		
AI	2.000	2.020		2.003	2.001	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: One / JL
 Date: 08/07/02 / 08/07/03

Audited by: SL
 Date: 08/07/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>SL</u> <u>GL</u>

